

ABSTRACT

A process for producing a foamed article of a thermoplastic resin composition having a relatively thicker solid skin layer exhibiting better appearance without occurrence of swirl mark and having a foam structure of relatively uniform foam cell size with better foam cell configuration, which is light-weighting and superior in the stiffness, in an easy and efficient manner, by causing the said resin composition to foam up in a cavity of a mold, which process comprises

a primary injection step in which a part amount of the thermoplastic resin composition is injected into the mold cavity defined by a stationary mold element and a movable mold element settled at a position confining the mold cavity to a volume smaller than the total volume of the thermoplastic resin composition necessary for making up each complete foamed article, while imposing a clamping pressure on the movable mold element,

a secondary injection step, in which the residual amount of the thermoplastic resin composition is further injected into the mold cavity, while drawing back the movable mold element, and

a foaming step, in which injection of the thermoplastic resin composition is stopped and the movable mold element is caused to further draw back so as to permit the thermoplastic resin composition to foam up.